

Work Order ID 50231

July 14, 2009 10:28:16 AM



Page 1

Item ID: D3793-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearshoe

Start Date: 7/15/09

Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: *09-07-15* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3793	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3793 Dwg Rev: *A* Prog Rev: *A* 12-
Deburr if necessary

(5) B 9-7-08

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

(13) 1-B 9-7-08

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 809107/30

(413) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50231

July 14, 2009 10:28:16 AM



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Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

1-Deburr if necessary □ 2-Form on Brake as per Dwg D3793 using Jigs □ 3-Form
Joggle on brake using Jig as per Dwg D3793

9/30/07/30 (13)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> 8/29/07/30

(13) 6

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M109091

Memo

0.00

START TIME: 8:10 AM OVEN TEMPERATURE:
8:40 AM FINISH TIME: 320°F

=> 09-07-31 (13) JH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Item Name: Wearshoe

Start Date: 7/15/09

Start Qty: 10.00

Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: FP-18

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



09-07-31 (B)

09-07-3 (X13)

09-08-05

31-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 10:28:15 AM

Page 1

Work Order ID: 50231

Parent Item: D3793-1RevA

Parent Item Name: Wearshoe

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	111.7100	6.2126	13		



304/316 .040 Sheet

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

111.71

110076

32.79

111571

78.92

41571

189-7-28

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50231
Description: Wearshoe		Part Number:	D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

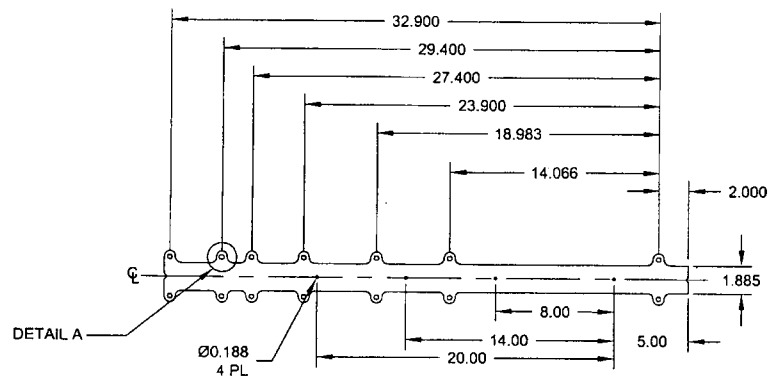
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.191	*			
0.300 x 0.300	+/-0.010	303 x 305	X			
1.885	+/-0.010	1.886	X			
2.000	+/-0.010	2.000	X			
5.00	+/-0.030	5.002	X			
8.00	+/-0.030	8.00	*			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	*			
14.066	+/-0.010	14.066	X			
18.983	+/-0.010	18.983	X			
23.900	+/-0.010	23.900	X			
27.400	+/-0.010	27.400	X			
29.400	+/-0.010	29.400	X			
32.900	+/-0.010	32.900	X			
0.040	+/-0.010	.039	*			

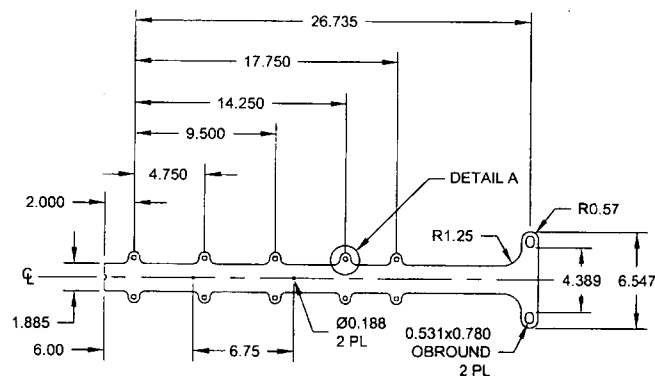
Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	97-28	Date:	08/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

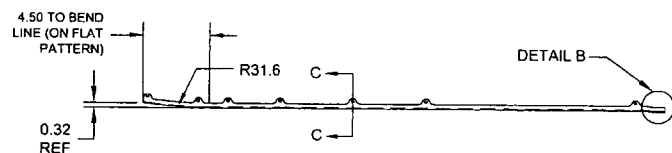
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50031
MF 09-07-15

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH		BY	DATE
DRAWN	PH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

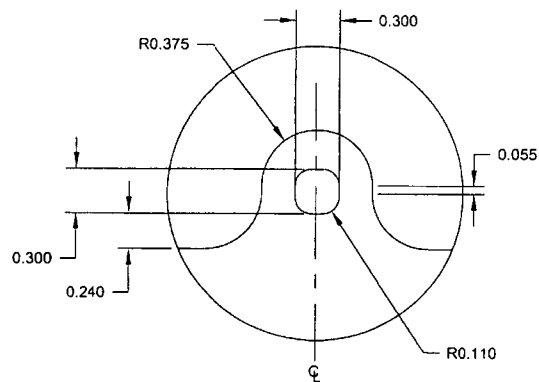
DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3793
TITLE WEARSHOE
REV. A
SHEET 1 OF 2
SCALE NTS

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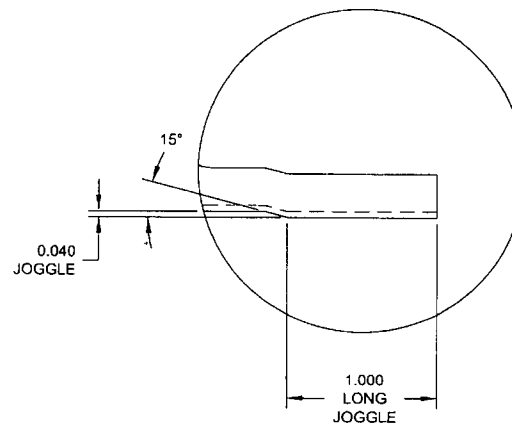
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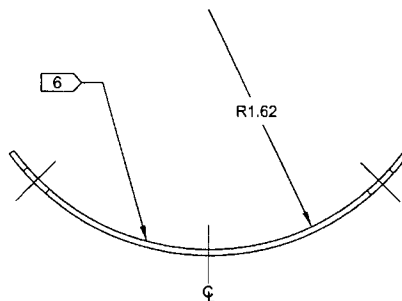
DETAIL A
SCALE 10X



DETAIL B
SCALE 10X

C

B



SECTION C-C
SCALE 10X

A

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50231
MF 09-07-15

RELEASED
08-00-23 1/8

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1